

Work Order ID 83077

83077

Page 1

April-12-12 4:09:40 PM

Item ID: D3439-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Stud

Stop

NS2

Start Date: 12/04/2012 Start Qty: 50.00

50

Cust Item ID:

Required Date: 26/04/2012 Req'd Qty: 50.00

50

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/04/13

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3439	B								

100

0.00

100

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

TURN AS PER FOLIO FA959

FOLIO REV:

DWG REV: B

DEBURR

SL 12-06-01

(50)

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

SL 12-06-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Cust Item ID:

Required Date: 26/04/2012 Req'd Qty: 50.00

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120 QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

aml 12/06/01

50

130 Identify as per dwg & Stock Location

0.00

130

Packaging

Memo

0.00

Packaging

SI GA

50x

SP 12-6-1

140 QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

12/6/14

MW 12/06/01

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Picklist Print

April-12-12 4:09:43 PM

Page 1

Work Order ID: 83077

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Parent Item: D3439-3

D3439-3

Parent Item Name: Stud

Start Date: 12/04/2012

Required Date: 26/04/2012

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP Rev:A 10.09.08 new issue verf:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303R0.500		Purchased	No			100	f	262.4750	0.113	5.947368			

M303R0 500

303 Round Bar 0.500"

**

12-06-01

Location

Loc Qty

Loc Code

MAT028

262.475

117143

11.34

118271

11.9

118509

2.36

119009

140.088

119616

96.787

121728

6-0

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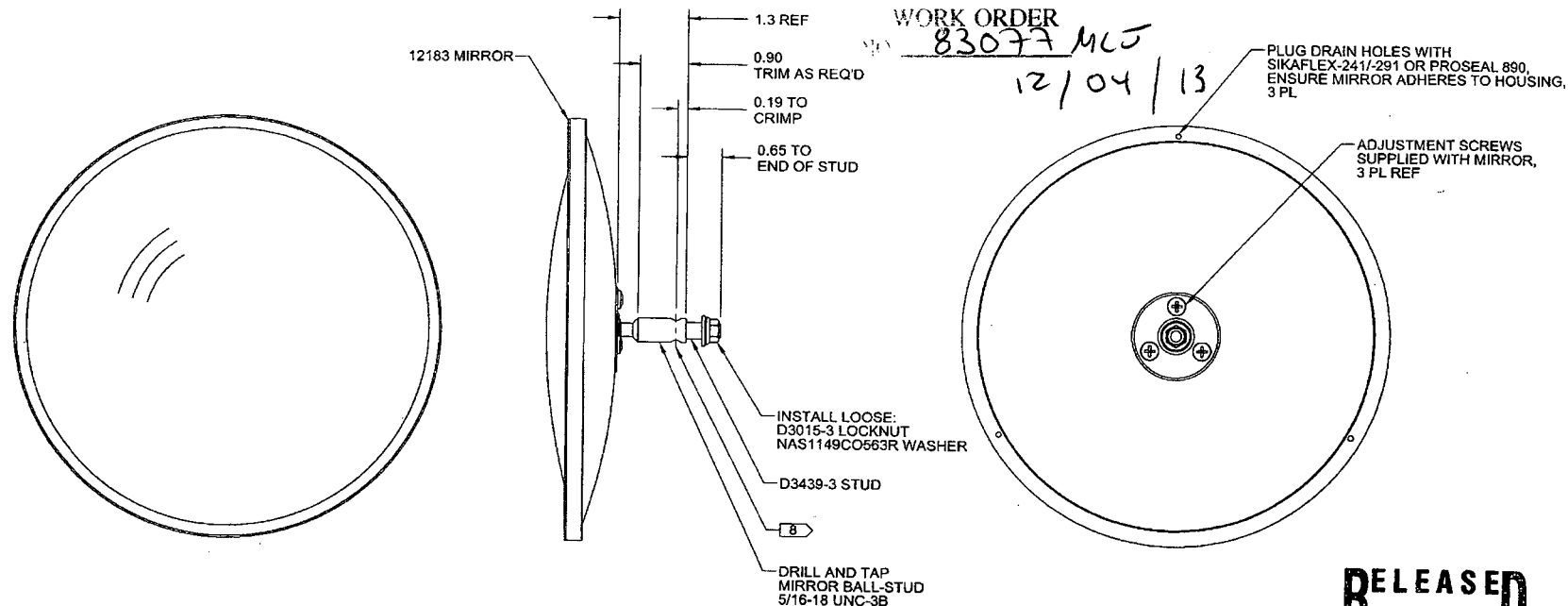
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WITHOUT NOTICE
WORK ORDER

ITEM	QTY	P/N	DESCRIPTION
1	X	D3439-101	MIRROR ASSEMBLY, 8"
2	1	12183	MIRROR 8" (GROTE)
3	1	D3015-3	LOCKNUT
4	1	D3439-3	STUD
5	1	NAS1149CO563R	WASHER (OR AN960JD516)



D3439-101 MIRROR ASSEMBLY

NOTES:

- 1) MATERIAL: MIRROR= 8" ROUND CONVEX MIRROR W/ STAINLESS STEEL CASE
CENTER-MOUNT BALL-STUD W/ 1/4-20 X 1" DEEP FEMALE THREAD
GROTE INDUSTRIES, 2600 LANIER DRIVE, MADISON, INDIANA 47250
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3439-101" USING REMOVEABLE TAG
- 7) WEIGHT: 1.18 lbs
- 8) TO INSTALL D3439-3 STUD:
 - APPLY LOCKTITE 262 TO THREADS BEING INSTALLED INTO MIRROR BALL-STUD
 - THREAD D3439-3 STUD INTO MIRROR BALL-STUD
 - CRIMP MIRROR BALL-STUD ON OPPOSING SIDES, 0.19 FROM END AS ILLUSTRATED USING TOOL DT8317
 - CRIMP TO DEPTH OF 0.015-0.030 USING R0.125

RELEASED
2010-09-07

B	REDRAW, ADD -3 (WAS PURCHASED/TRIMMED BOLT).	CP	10.07.20
A	NEW ISSUE	CP	05.05.27
REV.	DESCRIPTION	BY	DATE
DESIGN	JP		
DRAWN	JP		
CHECKED	JP		
MFG. APPR.	JP		
APPROVED	JP		
DE APPR.	JP		
DATE	10.07.20		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWING NO. D3439		REV. B	SHEET 1 OF 2
TITLE MIRROR ASSEMBLY		SCALE	NTS
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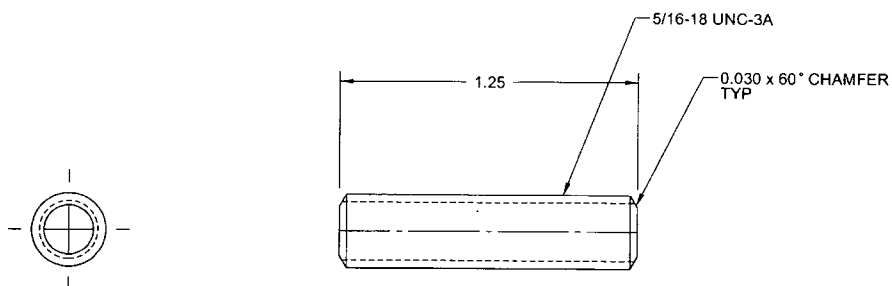
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D3439-3 STUD

RELEASED
2010-09-07

NOTES:

- 1) MATERIAL: AISI 303 STAINLESS STEEL ROUND BAR PER ASTM A582
REF DART SPEC M303R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.03 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3439	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		MIRROR ASSEMBLY	NTS
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